

## HPS 41814

### Product Description

**Hernon® Porosity Sealant (HPS) 41814** is the solution to leak proof parts, improving machinability, in addition to increasing the durability and surface quality for painting and plating. The hardened resins exhibit superior chemical resistance and elevated temperature stability.

The microscopic voids, where potential leaks occur (between metal grains or ceramic plastic molecules) in the part are filled by the low viscosity resin during vacuum application. Sealed micropores cure without shrinkage when exposed to elevated temperature to form tough cross-linked thermoset polymer, permanently sealing the workpiece. Residual adhesive film is water-washed from the part surfaces during rinsing.

The parts leave the impregnating process without surface residue and can then be used in production immediately. When used in preparation for plating or painting processes, the impregnation process also eliminates absorption of plating materials (like acids) or painting prep solvents that could otherwise later bleed out of pores causing finishes to discolor, bleed, pit or peel.

Sealed powdered metal parts exhibit better machinability, enhanced tool life and better dimensional control.

### Product Benefits

- Single component
- Cost effective
- Provides superior stability and reliability
- High speed processing, parts are ready in 30 minutes from floor to floor
- Reliability – Hardened resin exhibits superior chemical and physical, elevated temperature resistance and pressure sealability.
- A simplified process permitting processing of treated parts: immediate painting or machining of impregnated parts is possible because **HPS 41814** resin leaves no residue.

### Typical Applications

- Pneumatic tool castings
- Automotive carburetors
- Engine blocks

- Water and fuel pumps
- Plastic molds
- Valves, manifolds
- Railway, truck brake parts
- Hydraulic pumps
- Steering gear components
- Compressor parts
- Powdered metal gun parts
- Regulators

### Typical Properties (Uncured)

Property	Value
Resin	Dimethacrylate blend
Appearance	Amber fluorescent liquid
Viscosity @ 25°C, cP	5 to 10
Specific gravity	1.03
Surface Tension, Dynes/cm	32.70
Flash point	See SDS

### Typical Properties (Cured)

Property	Value
Hardness, Shore D	70 to 80
Operating Temperature, °C (°F)	-55 to 150 (-65 to 300)

### Directions for use

**HPS 41814** can be activated with **Hernon® HPS Initiator 91 or Initiator 4322**.

Resin can be activated as follows:

To achieve a gel time of 6 to 9 minutes at 90°C, **Initiator 4322** can be added to **HPS 41814** at approximately %0.2 by weight.

Alternatively, this table below can be used to activate the resin.

HPS 994	HPS Initiator 92
1 Gallon	7-8 grams
5 Gallon	35-40 grams

Mix the Resin and Initiator thoroughly until completely dissolved before use.

# Hernon® Technical Data Sheet

## Dissipator® 745

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Impregnation system reactivity is monitored by measurement of the Gel Time of a small-controlled sample of resin taken from the system. The following operational parameters are presented as a “typical” scenario to assess cure rate of the impregnation process and system:

1. Keep Resin at temperatures between 60°F-80°F in Tank.
2. Gel Time @ 194°F (90°C) should be in the range of 3-5 minutes when activated.

**HPS 41814** has been formulated to produce Gel Times in the 6-9 minutes range @ 194°F (90°C). Should the Gel Time be below 5 minutes or above 10 minutes contact **Hernon®** Customer Service.

Higher temperatures produce quicker cure rates. **HPS 41814** cures within the range of 177°F (80°C) to 205°F (96°C).

Proper cure requires the workpiece to uniformly attain full cure temperature. Parts that do not transfer heat well will require longer processing times. Efficient thermal conductivity yields shorter processing cycles. Parts with heavier cross sections require longer exposure at heat to attain sufficient temperature internally. Carefully consider part geometry.

### General Information

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Safety Data Sheet (SDS).**

### **Disposal of Waste**

Wastes generated during the impregnation process can, in general, be adequately handled by conventional biological treatment methods. Since both the circumstances of use and local environmental requirements vary, waste disposal recommendations are somewhat application specific.

### **Storage**

**HPS 41814** should be stored in a cool, dry location in unopened containers at a temperature below 77°F (25°C). To prevent contamination of unused material, do not return any material to its original container.

**HPS 41814** in an active impregnation system with normal use has unlimited pot life if recommended controls are maintained, including temperature controls.

Activated resins should be stored refrigerated. Do not allow continuous exposure to ultraviolet light. **HPS 41814** does not require aeration.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING®, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO 9001 Quality Standard.